

27

Date: Tuesday, 6/19/2007 2:03:34 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD X-TUBE EXTENDED HEIGHT GEAR (-011)
Job Number : 32940	
Estimate Number : 10007	
P.O. Number : <u>N/A</u>	Part Number : D205596101
This Issue : 6/19/2007 S.O. No. : <u>N/A</u>	Drawing Number : D205-596-101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : LANDING GEAR	Drawing Revision : A
Previous Run : 32939	Material : <u>N/A</u>
Written By : _____	Due Date : 7/6/2007 Qty: 1 Um: Each
Checked & Approved By : <u>KS 07.06.20</u>	
Comment : Est Rev G Removed Bending 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Photocopy D205-594 bluefile & type labels per PPP D205-596-101 CHG001

KS 07.06.20 (1)

2.0	D2889	FWD Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
FWD Crosstube
Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	<u>B33022</u>

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE
Bend as per Dwg D2889

EL 77-4

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
Mark 31.53" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.
Identify off-cuts with batch number & part number and bring them to cnc lathe

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

KS 07.06.20 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:03:34 PM
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Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 32940

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

7-7-4

1-Cut as per Dwg D205-596-101

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and end of tube.

Batch # on one

50 7-7-4

7.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

7-7-4

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat per QSI 005 4.1

50 7-7-4

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside and outside with Immron per QSI 005 4.2

ml 07/07/05

①

10.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

25 07-07-06

11.0

D2856600851

Abrasion Strip



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Abrasion Strip

Pick:

Qty Part number

Description

Batch

2

D2856-600-851 Abrasion Strip

26650

ml 07/07/06

12.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support

Pick:

Qty Part number

Description

Batch

2

D2893-1

Support

25524

ml 07/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 32940

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

4 MS21920-24

Clamp

M103955

ml

070706

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-101. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

070706

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

070706 (CL)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-101

Location:

REVIE

070706 @

SD

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

070706 (1)

Job Completion



070706

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

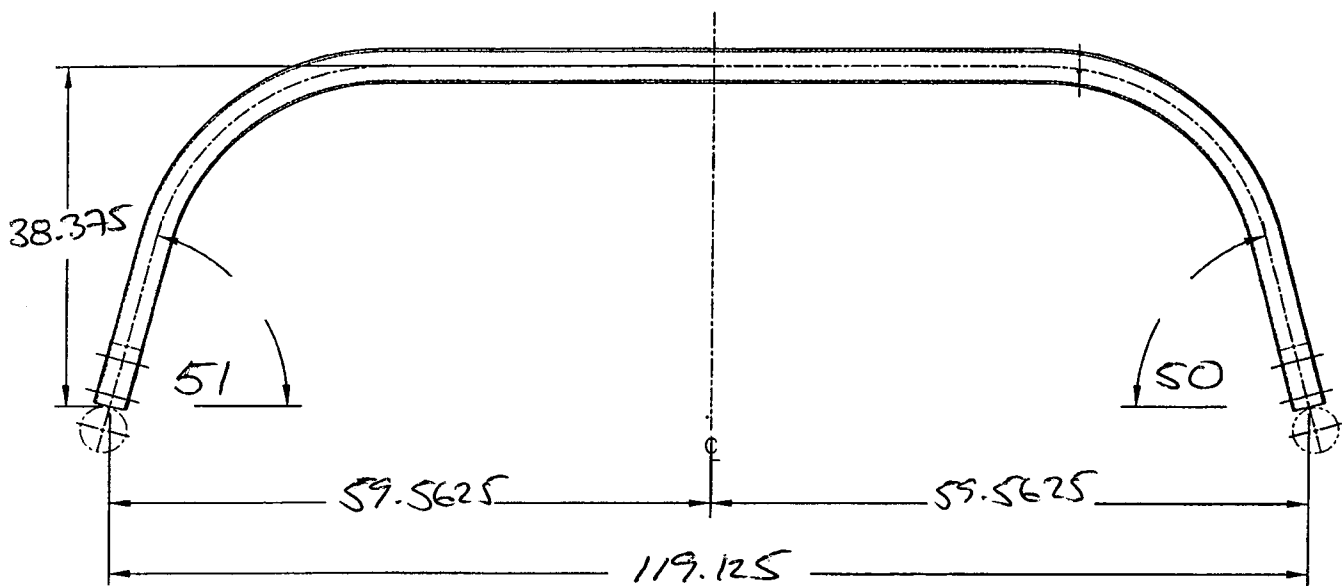
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32940
Description: Crosstube High-High Fwd		Part Number:	D205-596-101
Inspection Dwg: D205-596-101 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	38.2	38.4
1/2 Span	59.5	59.7
Angle	49	52
Total Span	119.0	119.4

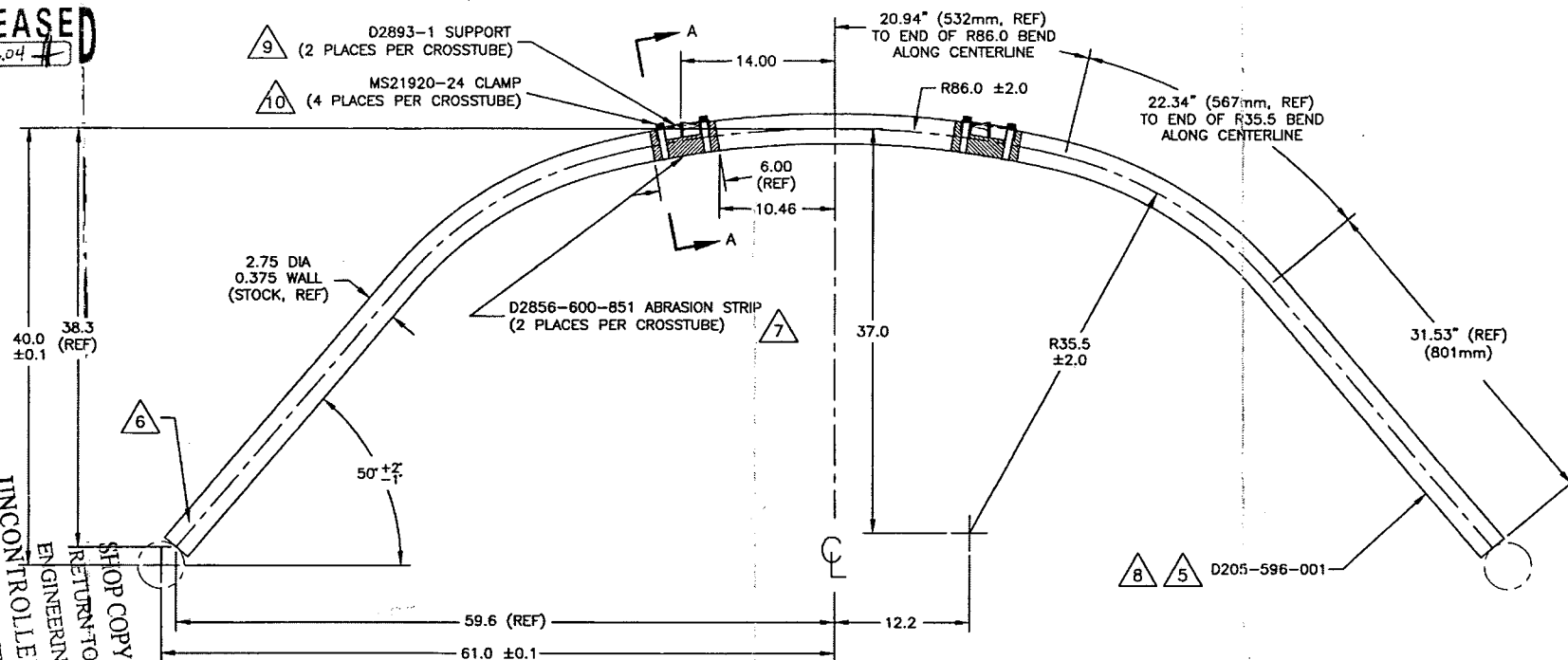


Comments

QC15 Inspection	2
Date	07-07-04

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

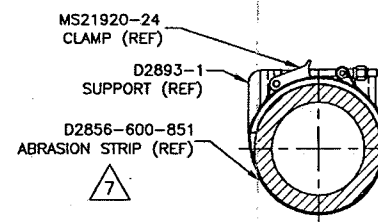
RELEASED
02.06.04



NO. 32940
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
ENGINEERING
SHOP COPY

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6005-180
FINISHED LENGTH = 149.60
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005\"
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB



SECTION A-A
SCALE 2:5

A		02.05.27	NEW ISSUE	
DESIGN	✓	DRAWN BY	CP	
CHECKED	✓	APPROVED	✓	
DATE	02.05.27	TITLE	XTUBE ASS'Y (HI-HI FWD)	
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				SCALE 1:10

